



Dart Aerospace Ltd.
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RB6872879
Job Sheet 192559

Part No: RB6872879

Job Qty: 1 pcs

Part Name: Spot Facing Fixture



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/27/19

Job Tracking No:

Due Date: 4/8/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RB6872879 Rev.4 IPP Rev. A 18.11.13 New issue DP Verify DD

Ship Via:

Bill of Materials

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
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Date: 04/15/19



Container No: S172401



Part: RB6872879

Job No: 192559

Serial No/Batch: S172401

Revision: 4

Inspector:

Exp Date:

Instructions:

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	4/5/19	0.00	0.20	Small Fab - 1		DAS	
						Small Fab - 2		71	
						Small Fab - 3		9-89	
						Small Fab - 4		19-4-15	
						Small Fab - 5			
						Small Fab - 6			
						Small Fab - 7			
110	QC 5	1 pcs	4/5/19	0.00	0.00	QC 5 - 10		APR 15 2019	
						QC 5 - 12			
						QC 5 - 17			
						QC 5 - 18			
						QC 5 - 19			
						QC 5 - 22			
						QC 5 - 24			
						QC 5 - 3			
						QC 5 - 43			
						QC 5 - 49			
						QC 5 - 51			
						QC 5 - 58			
						QC 5 - 68			
						QC 5 - 9			
						QC 5 - 50			
						120	Packaging 3-1 - Stock - B4B		1 pcs
Packaging 3 - 2 - B4B		28							
Packaging 3 - 3 - B4B									
Packaging 3 - 4 - B4B									
Packaging 3 - 5 - B4B									
Packaging 3 - 6 - B4B									
Packaging 3 - 7 - B4B									
Packaging 3 - 8 - B4B									
Packaging 3 - 9 - B4B									
Packaging 3 - 10 - B4B									
130	QC 21 - FG	1 pcs	4/5/19	0.00	0.00	QC 21 - FG - 21		DAS	
						QC 21 - FG - 70		21	
						QC 21 - SA - 53		9-89	

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
9435K81	302 Stainless Steel Corrosion-Resistant Compression Springs, 0.813" Long, 0.36" OD, 0.276" ID	1 Ea (1 ea)	100-Small Fab - 1	S128819
RB6872879-1	Socket Head Cap Screw	1 pcs (1 ea)	100-Small Fab - 1	S129540
RB6872879-3	Counterbore Cutter	1 pcs (1 ea)	100-Small Fab - 1	S168159

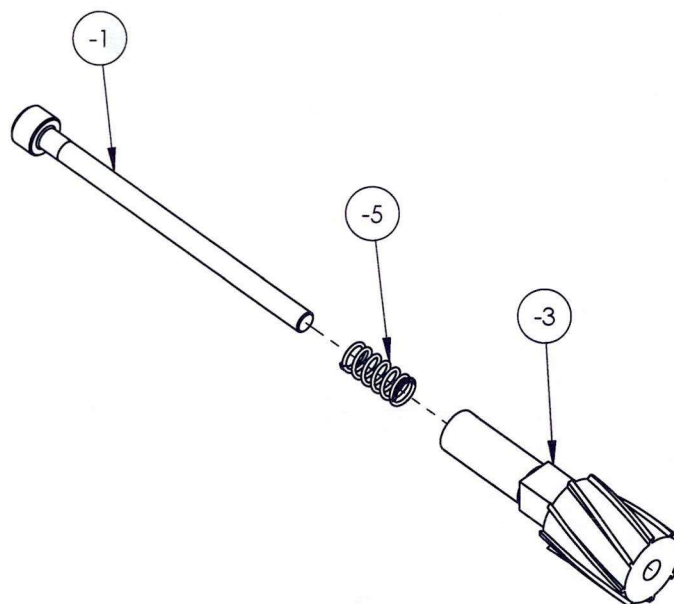
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	9435K81	1	4	0
	RB6872879-1	1	2	0
	RB6872879-3	1	0	0

Part Specifications
Specifications could not be found.

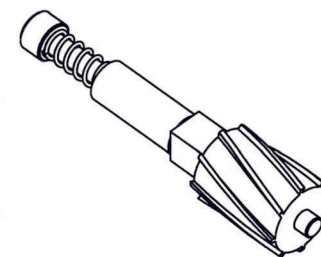
Plex 3/27/19 11:33 AM Dart.lajeunesse.marie

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
A		CORRECTED DWG. NO. FROM 6872879 TO RB6872879.	10/7/2010	RJC	
B		CH'D TITLE FROM FIXTURE - SPOTFACING, ADDED -7 BACK INTO BOM.	12/15/2010	RJC	RW
3	16-0030	-1 CH'D DIM WA Ø.248 Ø.002 A IS Ø.2490 - .2484 S.F. -3. ADDED DATUM A, CH'D DIM WAS .250-28 UNF-2A PD OF THD TO BE CONCENTRIC WITH DIA. WITHIN .002 TIR IS 1/4-28 UNF -2A .002 A, ADDED BLACK OXIDE FINISH. -3 ADDED SECTION VIEW A-A, ADDED DIM'S 1.19, Ø.2505 -.2500 S.F. -1. -5 CH'D B/O P/N WAS #94351281 IS 9435K81.	2/11/2016	RJC	JAG
4	16-0187	-1 CH'D DIMS FROM 3.00 TO 3.70, FROM 4.00 TO (4.00). ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D. -3 ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D.	10/21/2016	DPD	JAG



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WITHOUT NOTICE
WORK ORDER
NO. 192559 M.C.
19-03-27



ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	SOCKET HEAD CAP SCREW	STEEL	5/16-24 X 4 (MCMASTER-CARR #91251A371) MODIFIED	2
			-3	1	COUNTERBORE CUTTER	STEEL	ARONSON CAMPBELL #PTS1 DE60060 MODIFIED	3
		B/O	-5	1	COMPRESSION SPRING	S.S.	Ø.36 O.D. X .81 (MCMASTER-CARR #9435K81)	1
		B/O	-7	1	CLEAN-OUT BOX	PLASTIC	1-3/16 X 4 X 8 (FLAMBEAU #K206)	N/S

DART AEROSPACE	
TITLE SPOTFACING FIXTURE	
DWG NO. RB6872879	REV 4
MAT'L HEAT TREAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 XX ± .01 ANGLES ± 5° X ± .1 SURFACES = 125/
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	ENGINE MODEL 250 SERIES
SCALE 1:2	DATE 5/13/2009
SHEET 1 OF 3	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					